



Dart Aerospace Ltd.  
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**D119-796-251**  
**Job Sheet 170330-A**



**Part No:** D119-796-251

**Job Qty:** 1 ea

**Part Name:** Aft Crosstube Installation With Step (No Hardware)



**Part Weight:** 0 lbs

**Status:** Scheduled

**Priority:** Medium

**Job Created:** 1/15/18

**Job Tracking No:**

**Due Date:** 1/26/18

**Created By:** Marie Lajeunesse

**Type:** Stock

**Description:**

**Note:** DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

**Ship Via:**

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 1 Ea  |            | 1/25/18  | 0.00      | 0.00    | Start Up Crosstubes-1 |           | APR 23 2018 |
| 130   | Crosstubes         | 1 pcs |            | 1/26/18  | 0.00      | 0.51    | Crosstubes-1          |           | APR 23 2018 |
| 140   | QC                 | 1 pcs |            | 1/26/18  | 0.00      | 0.00    | QC5                   |           | APR 23 2018 |
| 145   | DC                 | 1 pcs |            | 1/26/18  | 0.00      | 0.00    | DC                    |           | APR 23 2018 |
| 150   | Packaging          | 1 pcs |            | 1/26/18  | 0.00      | 0.00    | Packaging3-1          |           | APR 23 2018 |
| 160   | QC21-FG            | 1 Ea  |            | 1/26/18  | 0.00      | 0.00    | QC21                  |           | APR 23 2018 |

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 \*\*\*Torque all clamps to 50 IN-LBS max.\*\*\*  
Descriptions: 140 - \*\*\*RE-CHECK TORCQUE ON CLAMP AS PER DWG\*\*\*  
145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 002  
150 - Identify and pack for shipping as per PPP D119-796-251

### Job Allocations

| Operation                    | Component Part       | Required | Inventory | Allocated | Std Qty |
|------------------------------|----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation 170328 | D119-796-241 5048541 | ①        | 8         | 0         | 0       |
|                              | D5123-3 5006028      | ④        | 358       | 0         | 0       |
|                              | D5149-043 5039113    | ②        | 2         | 0         | 0       |
|                              | MS21920-25 5050048   | ④        | 149       | 0         | 0       |

### Part Specifications

Specifications could not be found.

Plex 1/15/18 9:44 AM Dart.lajeunesse.marie



**Container No:** S063823



**Part:** D119-796-251

**Job No:** 170330-A

**Serial No/Batch:** S063823

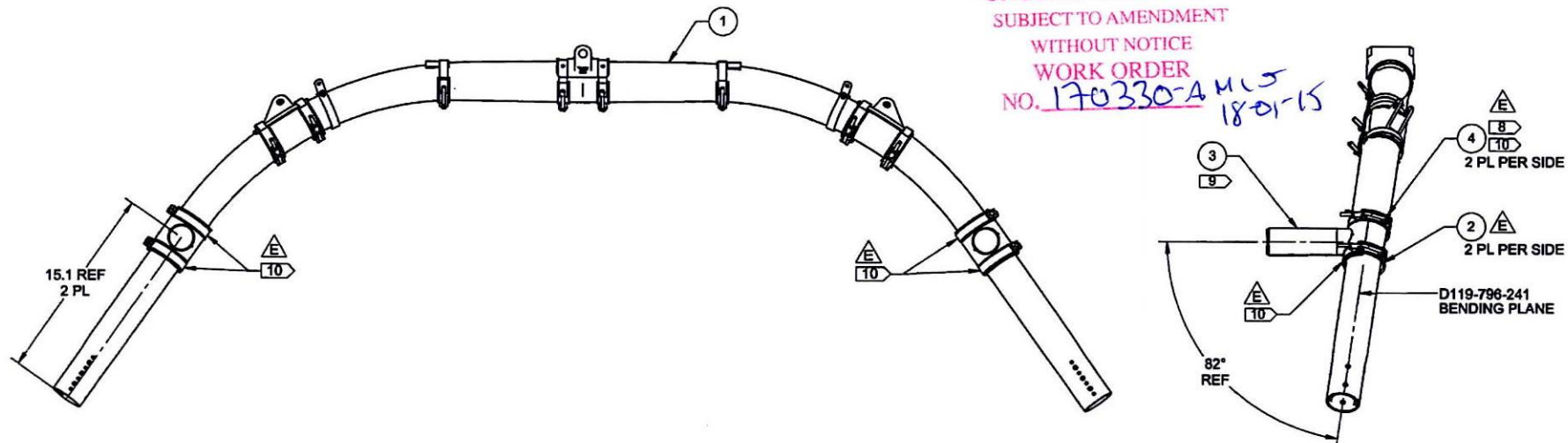
**Revision:** E/F

**Inspector:**

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| ITEM | QTY<br>-251 | P/N          | DESCRIPTION                 |
|------|-------------|--------------|-----------------------------|
|      | X           | D119-796-251 | XTUBE ASSY (AW119 MKII AFT) |
| 1    | 1           | D119-796-241 | XTUBE ASSY (AW119 MKII AFT) |
| 2    | 4           | D5123-3      | CUSHION                     |
| 3    | 2           | D5149-043    | AFT STEP ASSY               |
| 4    | 4           | MS21920-25   | CLAMP                       |

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WORK ORDER  
NO. 170330-A M.L.S.  
18-01-15



**D119-796-251 XTUBE ASSY (AW119 MKII AFT)**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 8.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
- 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.  
THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

|            |                                                                        |                                                                                                                                                                                                                                                                           |              |
|------------|------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| E          | MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR18-527) | ML                                                                                                                                                                                                                                                                        | 17.02.10     |
| D          | D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A             | AP                                                                                                                                                                                                                                                                        | 15.01.19     |
| C          | RE-DESIGN STEP INSTALLATION                                            | DB                                                                                                                                                                                                                                                                        | 14.11.24     |
| B          | D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A                    | AP                                                                                                                                                                                                                                                                        | 14.10.04     |
| A          | NEW ISSUE                                                              | AP                                                                                                                                                                                                                                                                        | 14.09.03     |
| REV.       | DESCRIPTION                                                            | BY                                                                                                                                                                                                                                                                        | DATE         |
| DESIGN     | AP                                                                     | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                  |              |
| DRAWN      | ML                                                                     |                                                                                                                                                                                                                                                                           |              |
| CHECKED    | NO                                                                     | DRAWING NO.                                                                                                                                                                                                                                                               | REV. E       |
| MFG. APPR. | DD                                                                     | <b>D119-796-251</b>                                                                                                                                                                                                                                                       | SHEET 1 OF 1 |
| APPROVED   | WM                                                                     | TITLE                                                                                                                                                                                                                                                                     | SCALE        |
| DE APPR.   | DS                                                                     | <b>XTUBE ASSY (AW119 MKII AFT)</b>                                                                                                                                                                                                                                        | NTS          |
| DATE       | 17.02.10                                                               | COPYRIGHT © 2014 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

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2017-05-04  
ECN 17-538

APPROVED